

Work Order ID 67695

Tuesday, March 29, 2011 1:00:32 PM



Page 1

Item ID:	D4148-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Crosstube Lug Assembly, Fwd				Stop	
Start Date:	3/29/2011	Start Qty:	4.00			
Required Date:	4/1/2011	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	1103-29	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	D								

100		0.00							
Small Fab	Memo	0.00		SB 1104107					
Small Fab	1- Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00		SB 1104108					
Quality Control									

120	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4148-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop



Start Date: 3/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/8
ME

11-04-08

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Tuesday, March 29, 2011 1:00:39 PM

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Required Date: 4/1/2011

Required Qty: 4.00

AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	42.0000	1	4		SB 11/04/07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				42					
				66029				3					
				66509				19					
				66873				20					
D3910-1  Crosstube Lug		Manufactured	No			100	Each	11.0000	1	4		SB 11/04/07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st507				11					
				65631				11					
D4091-1  Mounting Lug		Manufactured	No			100	Each	16.0000	1	4		SB 11/04/07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST460				16					
				65626				16					

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 1:00:39 PM

Page 2

Work Order ID: 67695

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 4.00

Required Qty: 4.00

D4148-1 Manufactured No

100 Each

4.0000

2 8



Crosstube Lug Plate, Fwd



SB 11/04/07

Location

Loc Qty

Loc Code

ST132 B67738
66889

4

4

2

4

D4148-3 Manufactured No

100 Each

0.0000

1



Stud Receiver, Lower

B 67733



③ SB 11/04/07

D4148-5 Manufactured No

100 Each

4.0000

1

4



Eyebolt Stud



SB 11/04/07

Location

Loc Qty

Loc Code

ST133
66890

4

4

3

8

AN3C12A Purchased No

100 Each

63.0000

2



Bolts



SB 11/04/07

Location

Loc Qty

Loc Code

ST351
115392
115594
116786
116924

63

3

5

5

50

6

12

AN4C13A Purchased No

100 Each

26.0000

3



BOLT



SB 11/04/07

Location

Loc Qty

Loc Code

ST357
116914

26

26

9

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, March 29, 2011 1:00:39 PM

Page 3

Work Order ID: 67695

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 4.00

Required Qty: 4.00

MS17984-C413 Purchased No

100 Each

10.0000

1 4



PIN, QUICK RELEASE



25 11/04/07

Location

Loc Qty

Loc Code

ST315

10

116823

10

3

MS20615-4M18 Purchased No

100 Each

61.0000

8 32



Rivet



SR 11/04/07

Location

Loc Qty

Loc Code

GA

61

115037

61

MS21043C3 Purchased No

100 Each

0.0000

2 8



Nut

M112344



8

SR 11/04/07

MS21043C4 Purchased No

100 Each

0.0000

3 12



Nut

M114523



9

SR 11/04/07

NAS1149C0332R Purchased No

100 Each

277.0000

4 16



Washer



SR 11/04/07

Location

Loc Qty

Loc Code

ST297

277

115832

46

116304

231

12

Tuesday, March 29, 2011 1:00:40 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 1:00:40 PM

Page 4

Work Order ID: 67695



Parent Item: D4148-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

1,650.000

6

24



Washer

SB 11/04/07

Location

Loc Qty

Loc Code

ST297

1650

116900

1650

18

Tuesday, March 29, 2011 1:00:40 PM

Shop Packet Print

Page 4

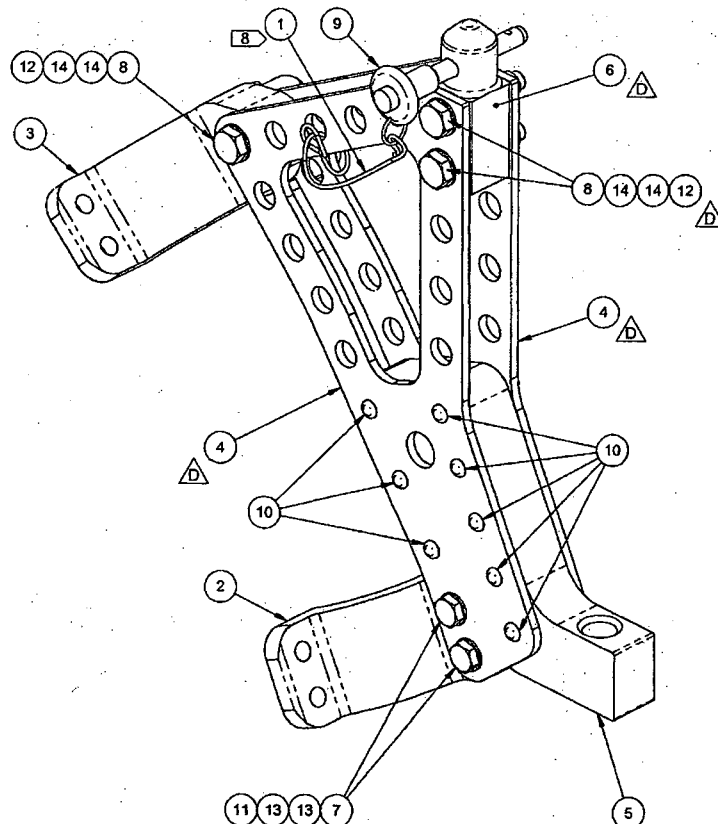
W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67695
2/11-03-29

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

RELEASED
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.129 3 PL REPLACES Ø0.129 3 PL (ZN D8-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

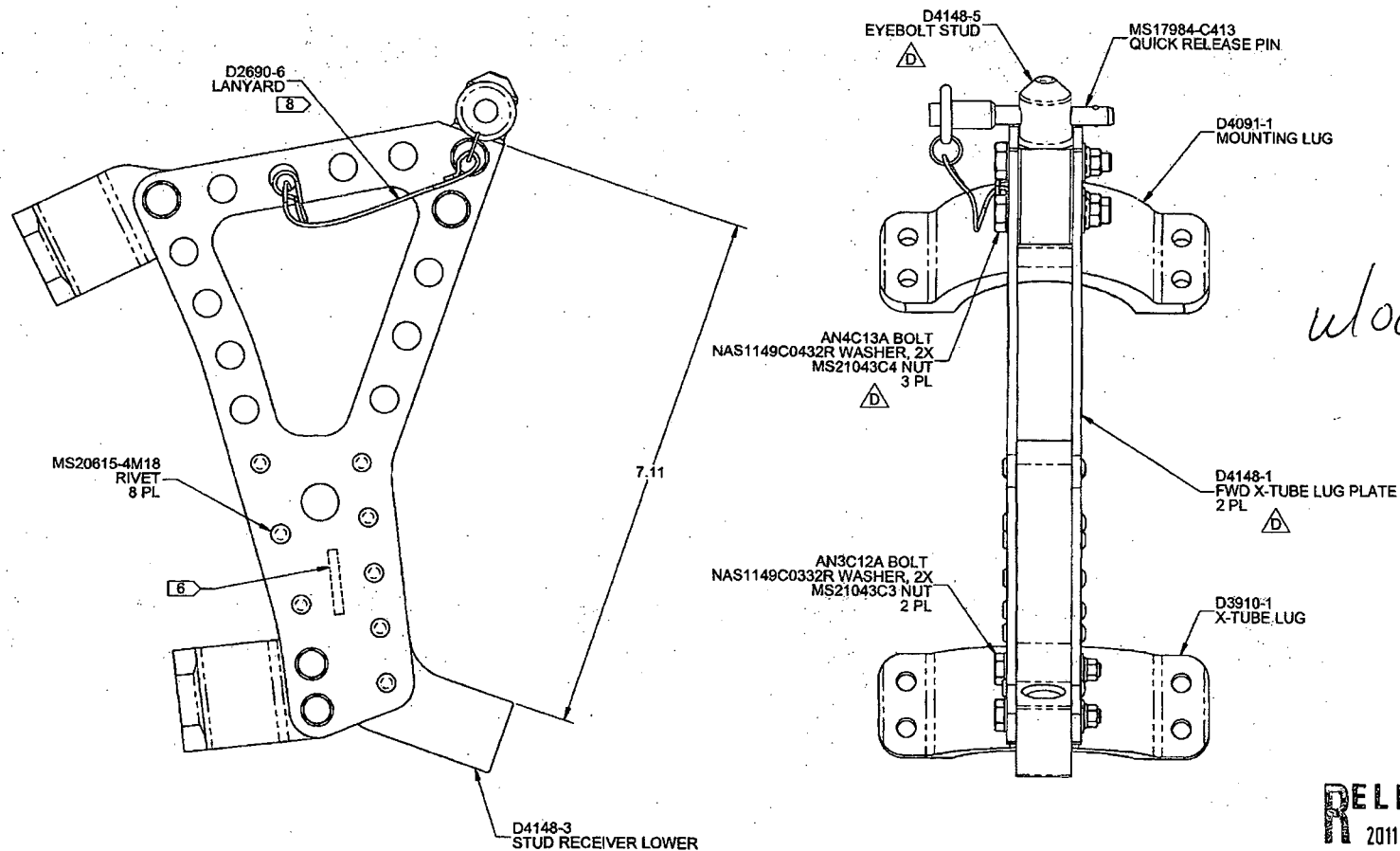
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NOTE: Date & initial all entries



W067695

RELEASED
2011-02-24
JM

D4148-041 FWD X-TUBE LUG ASSY

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4148	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

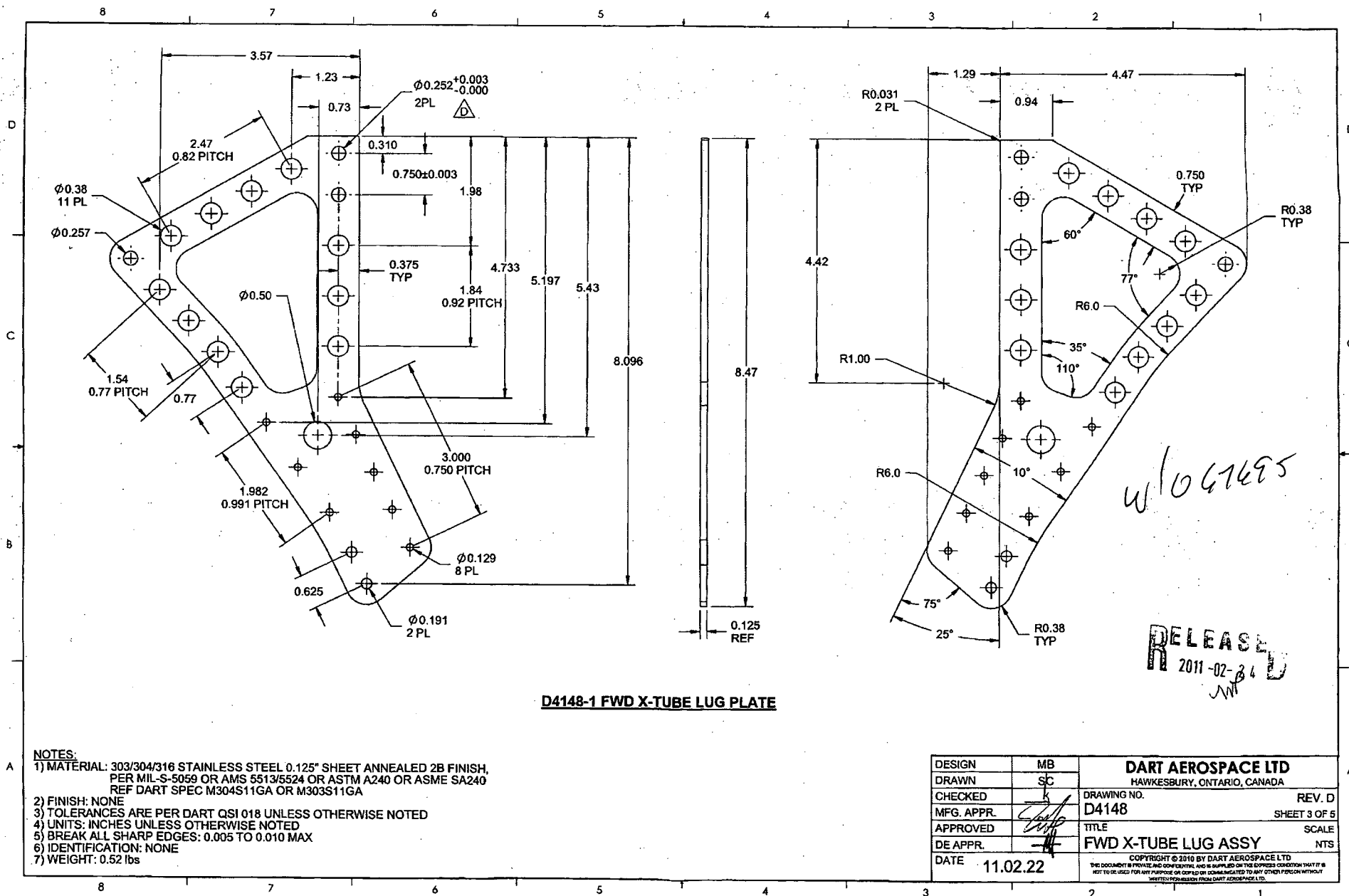
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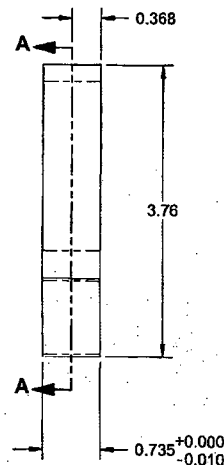
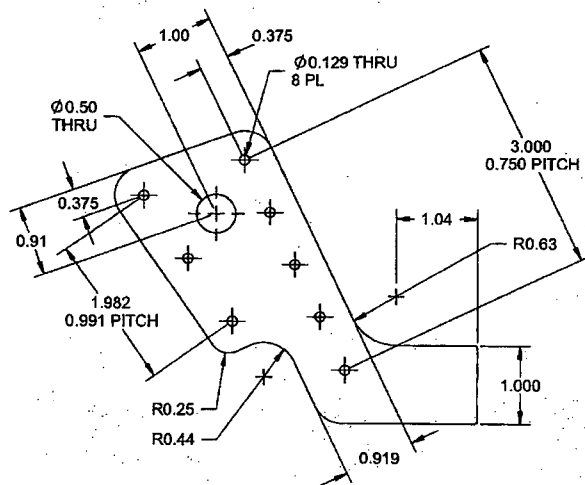
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D

C

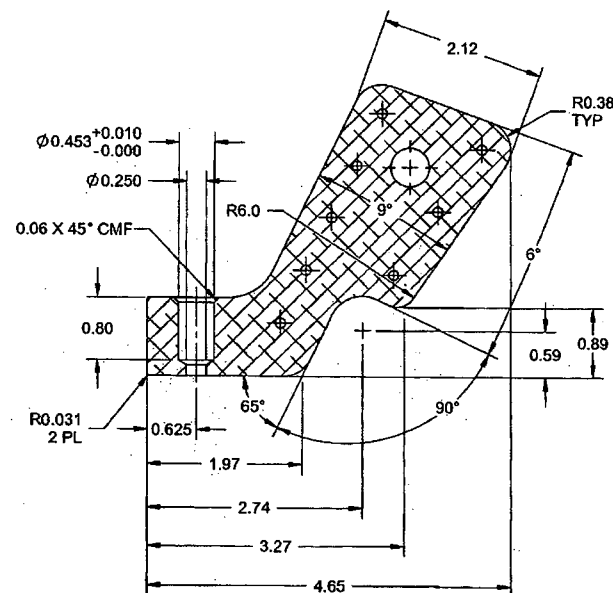
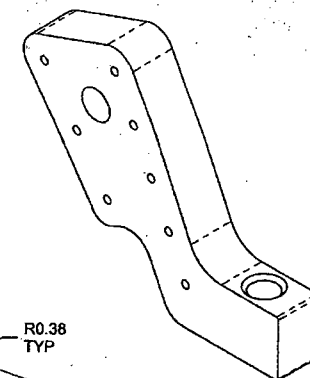
B

A



D4148-3 STUD RECEIVER LOWER

w/ 6 crans



SECTION A-A

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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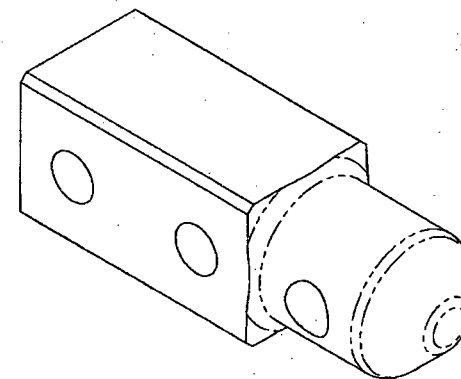
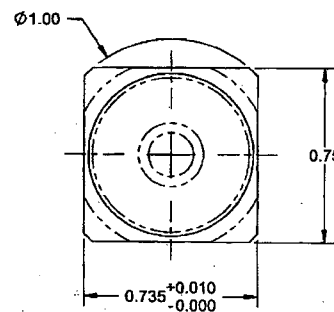
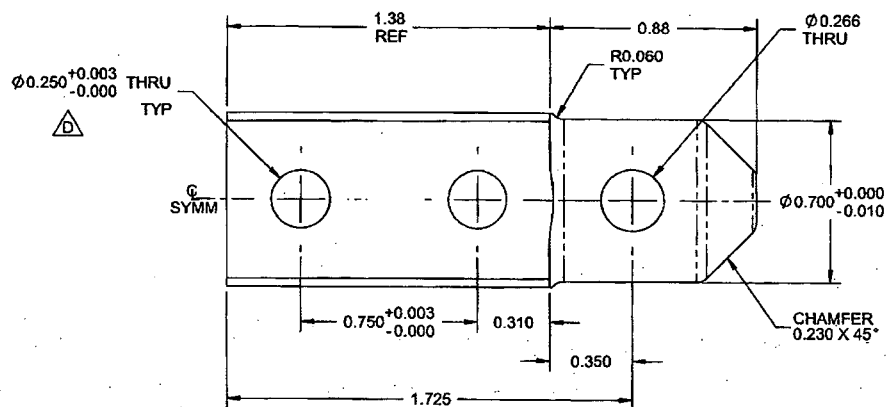
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-5 EYEBOLT STUD

w/o 67645

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries